

July 08, 2009 11:34:13 AM

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3814	Rev A								

100

0.00

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 7.100 " long

4
0.00
0.00
DIP 09/07/09

110

0.00

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA780 Rev: AA & Dwg D3814 Rev: A ☐ 2-Debur
per dwg D3814 ☐ 3-Finish tapping hole to final depth as per Dwg D3814

SL 09/08/09

120

0.00

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 09/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50119

Page 2

July 08, 2009 11:34:13 AM

Item ID: D3814-1 Accept Setup Start
Revision ID: A Stop
Item Name: Hinge, Upper Airframe
Start Date: 7/10/2009 Start Qty: 4.00 Cust Item ID:
Required Date: 7/31/2009 Req'd Qty: 4.00 Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start
QC: Date: SPC (Y/N): Date: Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:45pm □ OVEN TEMPERATURE: 2:15pm □ FINISH TIME: 3:20pm								

8/09/08/10
=> 09-08-10 (X4) JEF
M112260
=> 09-08-10 (X4) JEF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

July 08, 2009 11:34:12 AM

Work Order ID: 50119

Parent Item: D3814-1RevA

Parent Item Name: Hinge, Upper Airframe

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X04.50 0		Purchased	No.			100	f	5.0700	2.5263			

6061T6 Bar 2.00 x 4.500

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	5.07	
109425	5.07	

2,5263

DJP 09/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order: 50119
Description: hinge		Part Number: 3814-1
Inspection Dwg: D3814	Rev: A	Page 1 of 1

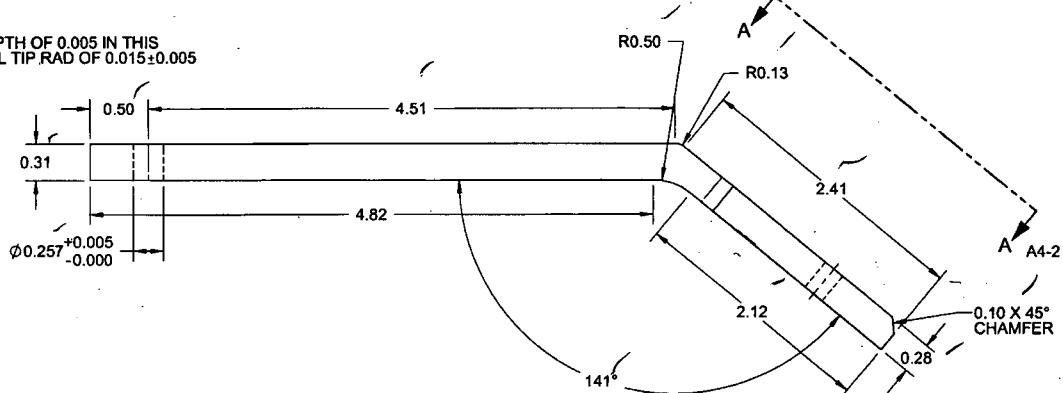
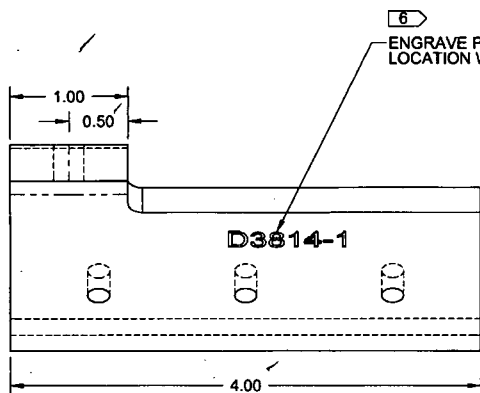
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	$\pm .030$.997	✓			
.50	$\pm .030$.499	✓			
4.00	$\pm .030$	3.998	✓			
Ø .257	$\pm .005$.258	✓			
.31	$\pm .030$.318	✓			
.50	$\pm .030$.500	✓			
Ø .50	$\pm .030$.500	✓			
4.51	$\pm .030$	4.505	✓			
2.41	$\pm .030$	2.415	✓			
100x45°	$\pm .030 \pm .5^\circ$	100x45°	✓			
.28	$\pm .030$.288	✓			
4.82	$\pm .030$	4.820	✓			
14/10	$\pm .50$	14/10	✓			
Ø .189	$\pm .005$.189	✓			
.75	$\pm .030$.751	✓			
.75	$\pm .030$.748	✓			
1.25	$\pm .030$	1.250	✓			
1.88	$\pm .030$	1.882	✓			

Measured by: JL	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/08/09	Date: 09/08/10	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3814-1 HINGE, UPPER AIRFRAME

50119

RELEASED
09/01/13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.36 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		08.11.10
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3814	REV. A
TITLE HINGE	SHEET 1 OF 3
SCALE NTS	

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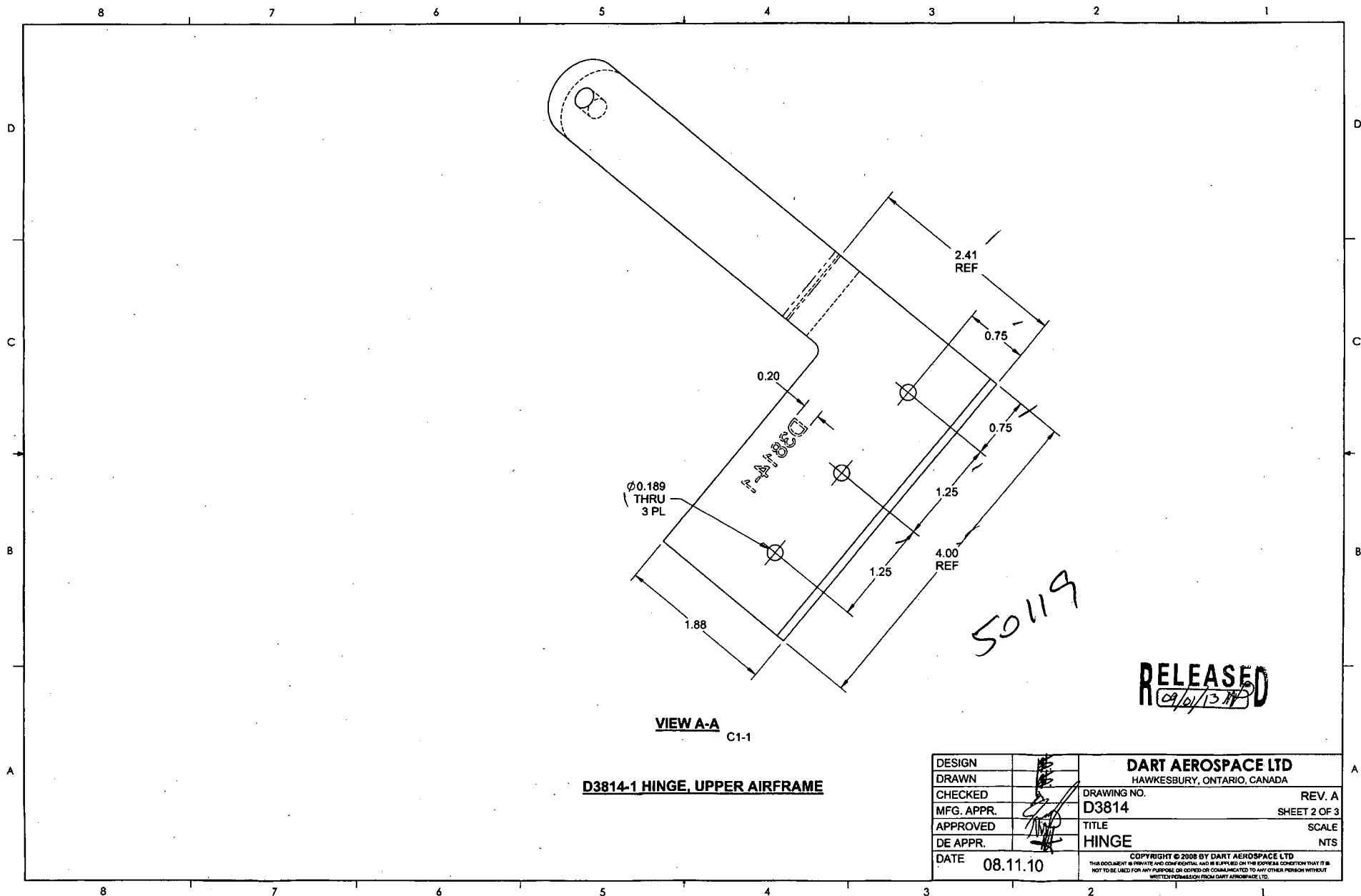
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NOTE: Date & initial all entries



D3814-1 HINGE, UPPER AIRFRAME

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3814	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	08.11.10	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
09/01/13

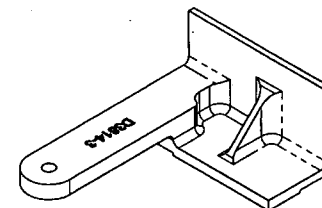
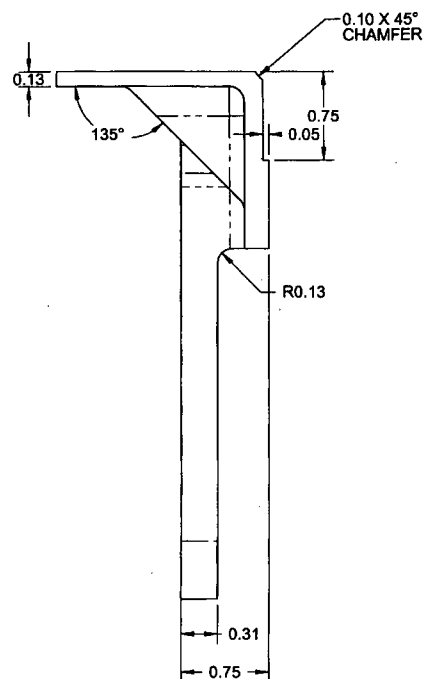
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NOTE: Date & initial all entries



5011a

RELEASE
09/01/13 NTH

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3


3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX

6) IDENTIFICATION: ENGRAVE P/N AS SHOWN

7) WEIGHT: 0.31 lbs.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3814	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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